

Slip Jan 13

Work Order ID 128007

128007

Page 1

Item ID: D4101-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Pre-Flight Step Assembly

Start Date: 12/18/14 Start Qty: 15.00

15

Cust Item ID:

Required Date: 12/22/14 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4101

B

100

0.00

100

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

9x

15/02/17

DAS
36
9-89

110

QCS- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

9

FEB 20 2015

DAS
36
9-89

120

Identify as per dwg & Stock Location

0.00

120

Packaging

Memo

0.00

Packaging

St 506

9

FEB 21 2015

DAS
36
9-89

Work Order ID 128007***128007***

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December-22-14 10:50:25 AM

Item ID: D4101-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pre-Flight Step Assembly
Start Date: 12/18/14 Start Qty: 15.00 ***15*** Cust Item ID:
Required Date: 12/22/14 Req'd Qty: 15.00 ***15*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

15/2/23

2-23

Picklist Print

December-22-14 10:46:03 AM

Page 1

Work Order ID: 128007

128007

Parent Item: D4101-041

D4101-041

Parent Item Name: Pre-Flight Step Assembly

Start Date: 12/18/14

Required Date: 12/22/14

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP Rev:A 10.07.07 new issue DD verf:JLM
10.12.08 PER DWG REV.B DD verf:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4101-1 *D4101-1* Bracket		Manufactured	No			100	Each	3.0000	1	15		15/02/19	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				3					
				81730				3		3			
D4101-3 *D4101-3* Step		Manufactured	No			100	Each	0.0000	1	15		15/02/19	DAS 36 9-89
D4101-5 *D4101-5* Spring		Manufactured	No			100	Each	20.0000	1	15		15/02/19	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST087				20					
				103161				17		6			
				93741				3		3			
AN4-22 *AN4-22* Bolt		Purchased	No			100	Each	25.0000	1	15		15/02/19	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST342				25					
				115669				15		9			
				m128199				10					

Picklist Print

December-22-14 10:46:03 AM

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Work Order ID: 128007

Parent Item: D4101-041

Parent Item Name: Pre-Flight Step Assembly

128007

D4101-041

Start Date: 12/18/14

Required Date: 12/22/14

Start Qty: 15.00

Required Qty: 15.00

NAS1149D0432J

Purchased

No

100

Each

1,170.000

2

30

NAS1149D0432.J

WASHER

DAS
36
9-89

15/02/19

Location

Loc Qty

Loc Code

ST269

1170

m131026

1170

NAS1149D0463J

Purchased

No

100

Each

6,439.000

2

30

NAS1149D0463.J

WASHER

DAS
36
9-89

18
15/02/19

Location

Loc Qty

Loc Code

CA

397

M129682

397

GA

408

M129390

408

ST260a

1155

M129390

1155

ST269

4479

M128591

8

M129390

12

M130799

4459

AN310-4

Purchased

No

100

Each

120.0000

1

15

AN310-4

Nut

DAS
36
9-89

18
15/02/19

Location

Loc Qty

Loc Code

GA

25

M127815

25

ST331

95

M128650

20

M129913

75

M131320
(9x)

Picklist Print

December-22-14 10:46:04 AM

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Work Order ID: 128007

128007

Parent Item: D4101-041

D4101-041

Parent Item Name: Pre-Flight Step Assembly

Start Date: 12/18/14

Required Date: 12/22/14

Start Qty: 15.00

Required Qty: 15.00

MS24665-136

Purchased

No

100

Each

80.0000

1

15

MS24665-136

Cotter Pins

**

15/02/19
DAS
36
9-89

Location

Loc Qty

Loc Code

ST294

80

2421

80

AN525-832R6

Purchased

No

100

Each

212.0000

1

15

AN525-832R6

Screw

**

15/02/19
DAS
36
9-89

Location

Loc Qty

Loc Code

CA

14

m129682

14

GA

12

125303

12

ST329

186

m130325

66

m130466

120

MS21209C0815

Purchased

No

100

Each

48.0000

1

15

MS21209C0815

Heli Coil, screw locking, red

**

15/02/19
DAS
36
9-89

Location

Loc Qty

Loc Code

ST299

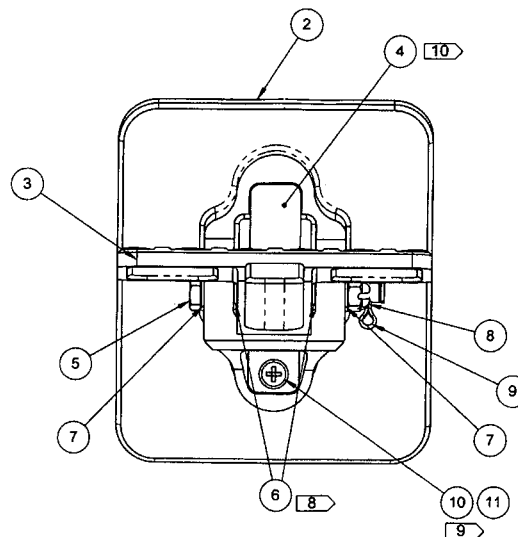
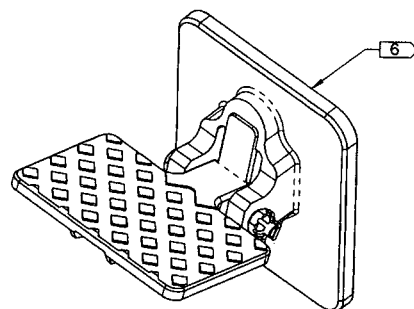
48

124328

12

124525

36



D4101-041 PRE-FLIGHT STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4101-041" USING FINE POINT PERMANENT INK MARKER BACK SURFACE
- 7) WEIGHT: 1.18 lbs
- 8) INSTALL NAS1149D0432J WASHER IN BETWEEN STEP AND BRACKET MATING FACES
- 9) TORQUE AN525832R SCREW TO 15-25 in-lb
- 10) TEXTURED SIDE TO BOTTOM

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4101-041	PRE-FLIGHT STEP ASSEMBLY
2	1	D4101-1	BRACKET
3	1	D4101-3	STEP
4	1	D4101-5	SPRING
5	1	AN4-22	BOLT
6	2	NAS1149D0432J	WASHER
7	2	NAS1149D0463J	WASHER
8	1	AN310-4	NUT
9	1	MS24665-136	COTTER PIN
10	1	AN525-832R6	SCREW
11	1	MS21209C0815	HELICOIL

RELEASED
2010-08-23

B	NAS1149D0432J WAS NAS1149D0416J (ZN D3-1); ADD SCREW AND HELICOIL (ZN D3-1& B1-3); RE-DESIGN D4101-5 (ZN B4-5)	RF	10.08.05
A	NEW ISSUE	RF	10.07.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. B
CHECKED	RF	D4101	SHEET 1 OF 5
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	PRE-FLIGHT STEP ASSEMBLY	NTS
DE APPR.	RF	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		